

Date: Tuesday, 9/26/2006 2:41:59 PM  
 Per: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BEARPAW KIT (19"X24")
<b>Job Number</b> :	28728		
<b>Estimate Number</b> :	10323		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	K10008
<b>This Issue</b> :	9/26/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2432 REV F3
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	28671	<b>Drawing Revision</b> :	F3
	<b>Type</b> :	<b>Material</b> :	P/A
	MACHINED PARTS	<b>Due Date</b> :	10/10/2006
<b>Written By</b> :		<b>Qty:</b>	10
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:J 04.02.17 Blank size changed KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile:  
 K10008  
 D206-559-013  
 D350-578-011  
 D427-659-011  
 D315-670-011  
 and create labels per PPP K10008  
 CHG006(Bag Bluefiles separately)

10

KS 06.09.26

2.0	MUHMWB10	UHMW 1" Black
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**Comment:** Qty.: 6.8250 sf(s)/Unit Total : 68.2500 sf(s)  
 blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5  
 Material: Black UHMW 1"  
 (MUHMWB10)  
 Batch: M102164

S.G./UP/J.F. 06/09/29

10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

S.G./UP/J.F. 06/09/29

10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 9/26/2006 2:41:59 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 28728

Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



J.G / C



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

UP / J.F. 06/09/29 10

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 06.10.03

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total: 25.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 6 D2182B050 Rubber Cushion B28042 ✓

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 D2274 Radius Block B28347 ✓ 108 → SORTI 107

→ 2 D2432F(ref only) Bearpaw B28728

B28824 12mc ✓

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 6 D2438 Clamp B28345 ✓

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 9/26/2006 2:42:00 PM  
User: Kim Johnston

## Process Sheet

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Drawing Name: BEARPAW KIT (19"X24")

Job Number: 28728

Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 D2529 Washer B27876

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4166 f(s)/Unit Total : 4.1660 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 6 D2732-050 Rubber Cushion B26472

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 AN4-15A Bolt M102037

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 AN4-17A Bolt M101124

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 24 AN960JD416 Washer M19185

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/15/11

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/26/2006 2:42:00 PM  
User: Kim Johnston

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Job Number: 28728

Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 MS21042L4

Nut (or -4)

~~M 19085~~ M 19099. 120 mes

PU 6/15/04

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

LB 06/10/11 (10)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10008

Location: REV E

LB 06/10/11 (10)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10)  
S 06/10/11

Job Completion



U 06-10-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>28728</b>
<b>Description:</b> Bearpaw		<b>Part Number:</b>	<b>D2432</b>
<b>Inspection Dwg:</b> D2432 <b>Rev:</b> F3		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060" x 45° ✓			
B	5.500	+/-0.030	5.502" ✓			
C	0.200	+/-0.030	.190" ✓			
D	0.25 x 45°	+/-0.030	.265" x 45° ✓			
E	R0.250	+/-0.030	R0.250" ✓			
F	0.250	+/-0.010	.240" ✓			
G	0.625	+/-0.030	.622" ✓			
H	0.375	+/-0.010	.376" ✓			
I	0.950	+0.030/0.010	.941" ✓			
J	19.000	+/-0.030	19.000" ✓			
K	3.14	+/-0.030	3.140" ✓			
L	3.28	+/-0.030	3.310" ✓			
M	Ø0.260	+0.005/-0.000	Ø.260" ✓			
N	Ø0.93	+/-0.030	Ø.930" ✓			
O	0.30	+0.030/-0.000	.310" ✓			
P	23.750	+/-0.030	23.750" ✓			
Q	7.375	+/-0.030	7.381" ✓			
R	4.250	+/-0.010	4.250" ✓			
S	2.000	+/-0.030	1.997" ✓			
T	9.000	+/-0.010	9.000" ✓			
U	9.000	+/-0.010	9.000" ✓			
V	0.375	+/-0.010	.378" ✓			

<b>Measured by:</b> J.F.	<b>Audited by:</b> SA	<b>Prototype Approval:</b> N/A
<b>Date:</b> 06/09/29	<b>Date:</b> 06.09.29	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue      P/O K10008/D206-559-015	KJ/RF	TF



DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	KE	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE
		1:6

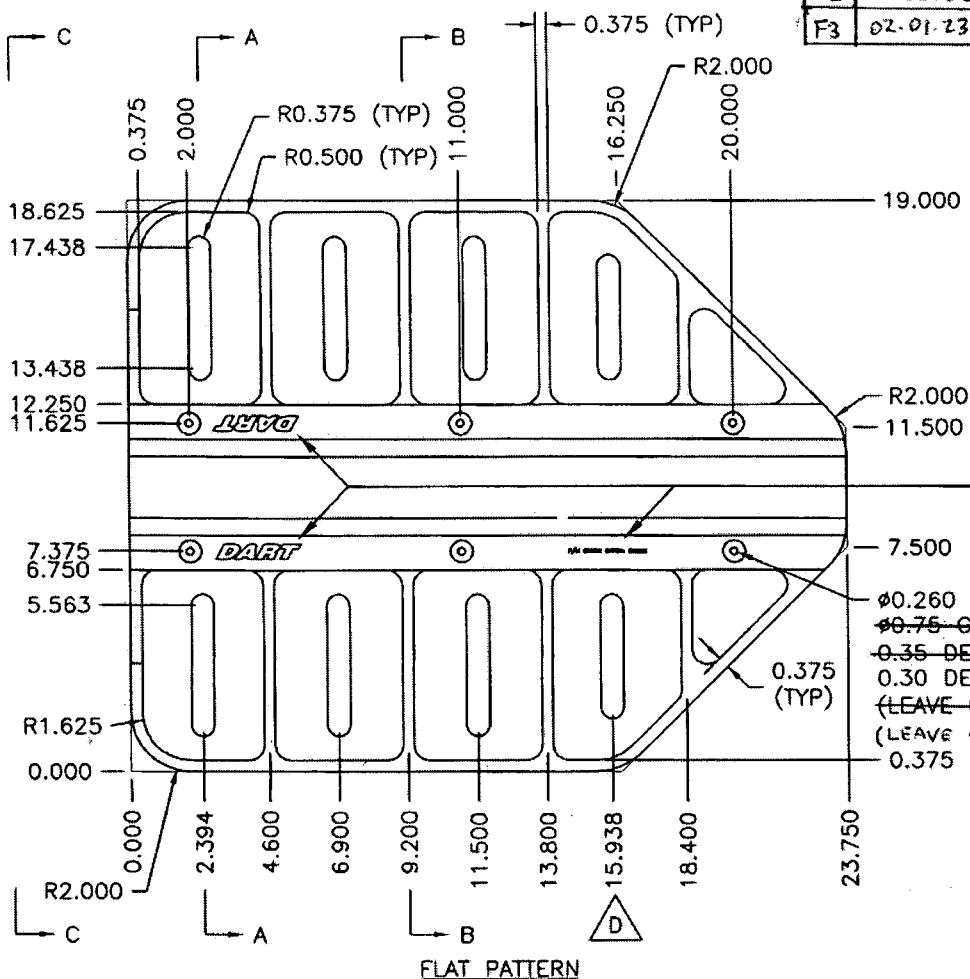
RELEASED  
98.06.17 KE

A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

EFFECTIVE	DEOS
9143	

F1	99.03.03	ADD DEO 9143
F2	01.03.28	<del>Ø0.93 WAS Ø0.75</del> RF
F3	02.01.23	CLARIFY BORE DIMS RF



Ø0.260 (TYP)  
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)  
(LEAVE 0.650 MIN.)  
0.375



D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

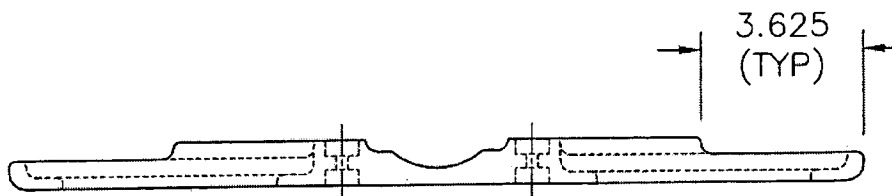
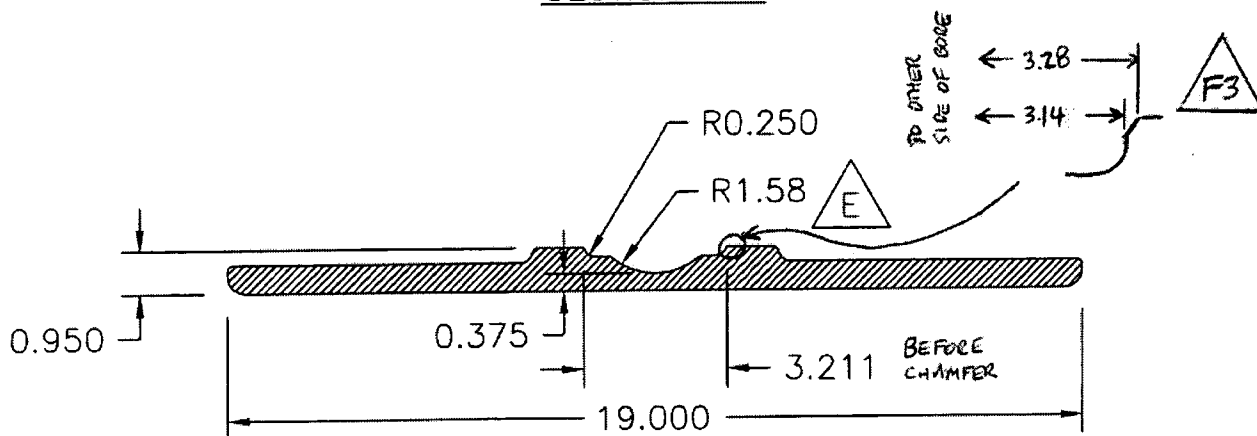
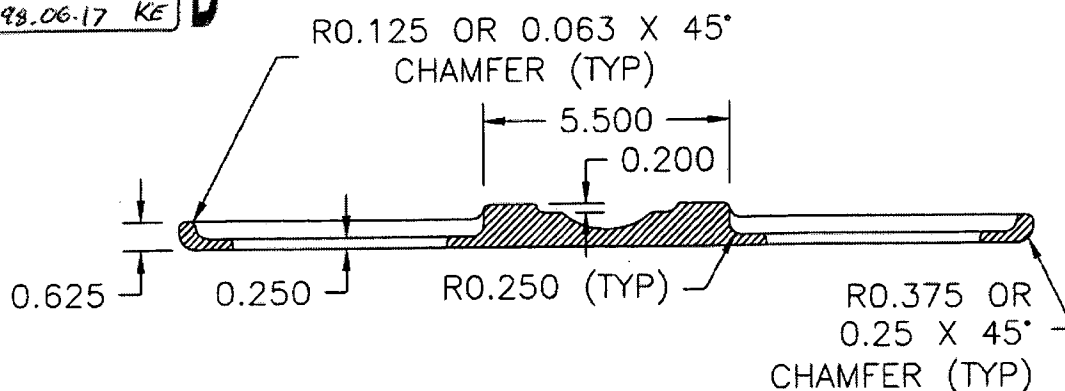


MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED  
98.06.17 KE



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